

Work Order ID 98942-2

March-28-13 10:47:09 AM

98942

Page 1

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MLC

QC:

Date: 13-04-01 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3078	A
-------	---

DSI 9472	A
----------	---

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

0.00

27
28
13416

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

0.00

4 φ 13.0408

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Page 2

Item ID: D350-591-213

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/10/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

DAS
19
9-83
13-04-10

130

Large Fab

0.00

130

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072
A/R Aluminum Rod 123324
3-Grind End Plate flush 123928

13-04-10

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

140

QC

Memo

0.00

Quality Control

13-04-10

Work Order ID 98942

March-28-13 10:47:09 AM

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step. Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Cust Item ID:

Customer:

Setup Start *NS1*

Stop *NS2*

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

150

150

QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

13-04-10

160

160

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

4 φ Ae 13 04 11

170

170

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

4 φ

DAS
19
9-89
13-04-11

98942

Accept

N900040100

Work Order ID 98942

March-28-13 10:47:09 AM

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Page 4

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

200

200

Large Fab

Large Fab

Large Fab

Memo

0.00

1- Rivet Leg Assembly as per Dwg D3078.
2-Bevel Aft end for welding
3-Inspect for foreign object as per QSI 024
4-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod 122324
5-Grind End Plate flush

1 φ

13.04.15

210

210

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

①

13.04.15

DAS 16 09 13.04.15

220

220

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS 16 09 13.04.15

4 LH

Work Order ID 98942

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Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

230

Chemical Conversion Coat per QSI005 4.1

0.00

230

HandFinish

Memo

0.00

Hand Finishing

1 HB 13-4-15

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

240

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3-30
3200
4-00
125182

1 X MF 13/04/15

250

Wing Walk as per dwg QSI005 4.4 Batch

0.00

250

HandFinish

Memo

0.00

Hand Finishing

1 φ HB-4-16.

M125069

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Page 6

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1611 d ell 13/04/16

270

Pick Kit

0.00

270

Packaging

Memo

0.00

Packaging



13-04-16

280

QC4- 100% Inspect kits for completeness

0.00

280

QC

Memo

0.00

Quality Control

DAS 27 13-04-16

Work Order ID 98942

March-28-13 10:47:09 AM

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Page 7

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

290

Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D350-591-213

Location: _____

PPP Rev: _____

0.00

0.00

0.00

0.00

300

300

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo



13-4-16

MLJ 13-04-16

RL 13-04-16

Picklist Print

March-28-13 10:47:08 AM

Page 1

Work Order ID: 98942
 Parent Item: D350-591-213
 Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13
 Start Qty: 4.00

Required Date: 4/10/13
 Required Qty: 4.00

Comments: IPP Rev:B05.10.14Modified step 10KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D 10.03.17 incorporate seq
 180 to 200 remove qc5 DD verified by:JLM IPP
 Rev:E 10.11.15 update qty on AN4-11A DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			110	Each	25.9700	0.5	2			

Ac 13-04-08

Location	Loc Qty	Loc Code
WA003	25.97	
75781	1	
81507	4	
89750	11.97	
93552	9	

D3067-1
 End Plate

Manufactured No

130 Each 337.0000 1 4

13-04-10

Location	Loc Qty	Loc Code
WA	108	
95515	35	
98655	73	
WA003	229	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95170	64	
95930	152	

4

Picklist Print

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Page 2

Work Order ID: 98942
Parent Item: D350-591-213
Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13
Start Qty: 4.00

Required Date: 4/10/13
Required Qty: 4.00

D3063-1
Support Manufactured No

130 Each 55.0000 1 4

13.04.10

Location	Loc Qty	Loc Code
WA003	55	
71886	15	
95754	40	

MS20600-AD4W4
Rivets Purchased No

180 Each 1,382.0000 16 64

13.04.15

Location	Loc Qty	Loc Code
ST311	672	
121011	9	
121340	39	
121444	220	
121652	18	
123900	386	
st507	676	
124331	676	
WA003	34	
123021	34	

D3066-1
Spacer Manufactured No

180 Each 27.0000

2 B95963 → (2) Ae 13.04.15

Location	Loc Qty	Loc Code
WA003	27	
94832	27	

D3065-041
Step Leg Assembly Hi Manufactured No

180 Each 6.0000

1 B98332 → (1) Ae 13.04.15

Location	Loc Qty	Loc Code
WA	5	
95772	5	
WA003	1	
79336	1	

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Shop Packet Print

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Picklist Print

March-28-13 10:47:08 AM

Page 3

Work Order ID: 98942

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

200 Each 337.0000 1 4

End Plate

13.04.15

Location	Loc Qty	Loc Code
WA	108	
95515	35	
98655	73	
WA003	229	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95170	64	
95930	152	

AN3-35A

Bolt

Purchased No

270 Each 133.0000 2 8

125211

SEP

SMA

Location	Loc Qty	Loc Code
FG	10	
122800	10	
ST352	123	
123525	40	
124552	83	

13-04-16

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Page 3

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Page 4

Work Order ID: 98942
Parent Item: D350-591-213
Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 4.00

Required Qty: 4.00

D2856-400 Manufactured No
Abrasion Strip

270 f 237.1099 0.6 2.4

20 50

Location	Loc Qty	Loc Code
ST410	162.076	
95159	162.076	
ST415	75.0339	95159
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	
90764	33.56	

AN4-11A Purchased No
Bolt

270 Each 264.0000 2 8

20 50

Location	Loc Qty	Loc Code
FG	20	
120731	20	
ST514	50	
123900	50	
ST517	194	
124221	194	124221

AN960JD416 Purchased No
Washer

270 Each 0.0000 12 48

20 50 13-04-16

D2230-1 Manufactured No
Lug

270 Each 170.0000 2 8

Location	Loc Qty	Loc Code
FG	4	
84136	4	
ST469	166	
89783	16	
95217	122	
95442	28	

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Picklist Print

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Page 5

Work Order ID: 98942
Parent Item: D350-591-213
Parent Item Name: Heli-Access-Step. Short LH

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 4.00

Required Qty: 4.00

MS210421.3
Nut

Purchased No

270 Each 5,370.0000 2 8

Location	Loc Qty	Loc Code
FP001	3	
122141	3	
GA	155	
122452	155	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	4944	
123900	1064	
124291	3880	

AN4-13A
Bolt

Purchased No

270 Each 888.0000 4 16

Location	Loc Qty	Loc Code
FG	20	
122808	20	
Return2012	8	
122416	8	
ST514	860	
122993	13	
123900	10	
124221	837	

D2732
Rubber Extrusion

Manufactured No

270 f 476.9462 1 4.2105264

Location	Loc Qty	Loc Code
ST410	476.9462052	
70987	0.3	
83560	3.5962052	
94725	473.05	

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Picklist Print

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Page 6

Work Order ID: 98942
 Parent Item: D350-591-213
 Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 4.00

Required Qty: 4.00

D2230-3
 Lug

Manufactured No

270 Each 174.0000

2

8

97903

JB

SP

Location

Loc Qty

Loc Code

FG
 89045
 ST469
 89782
 90514
 94957
 96117

4
 4
 170
 19
 1
 70
 80

270 Each 0.0000

4

16

124392

JB

SP

270 Each 3,110.0000

6

24

JB

SP

AN960JD10
 Washer

SP

NAS1149D0363J

Purchased

No

MS21042L4

Nut

Purchased

No

Location

Loc Qty

Loc Code

FP001
 122452
 8182
 FP-001
 8182
 GA
 121444
 ST314
 116548
 119017
 123248
 123355
 ST518
 124231

318
 306
 12
 12
 12
 34
 34
 76
 4
 20
 36
 16
 2670
 2670

124231

13-04-16

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Page 6

• Picklist Print

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Page 7

Work Order ID: 98942

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13

Required Date: 4/10/13

Start Qty: 4.00

Required Qty: 4.00

AN4-16A

Purchased

No

270

Each

195.0000

4

16

Bolt

SM

Location

Loc Qty

Loc Code

FG

5

121541

5

ST357

190

124215

190

124215

13-04-16

March-28-13 10:47:09 AM

Shop Packet Print

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3078	REV. A
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT	
A	02.09.11	NEW ISSUE	

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

98942 MC
13-04-01

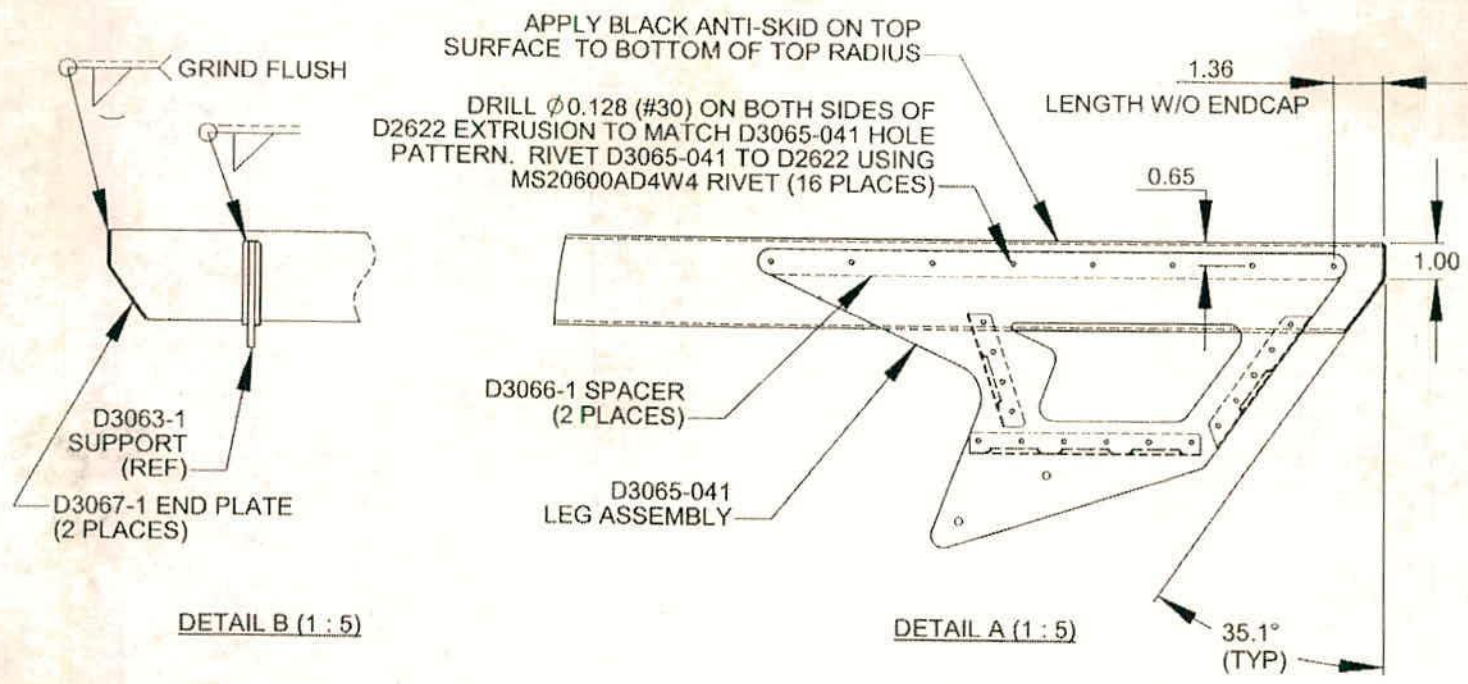
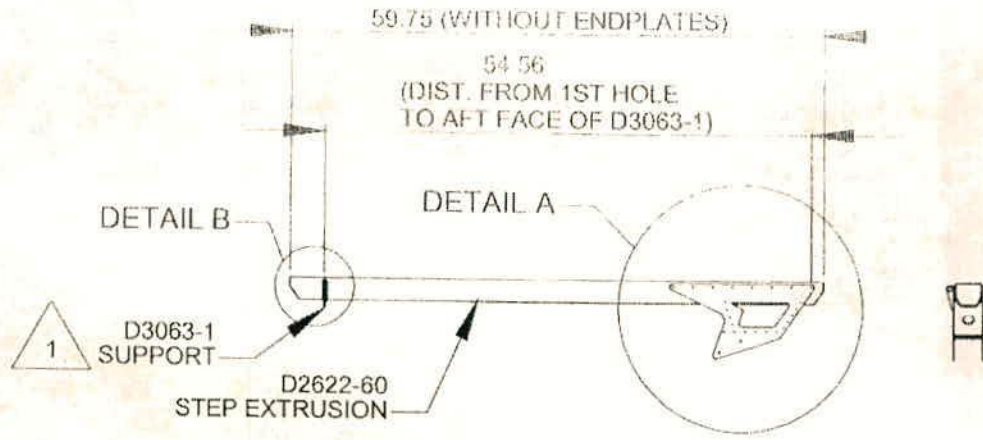
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98942



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		REV. A
02.09.11		SHEET 2 OF 2
	TITLE	SCALE
	STEP ASSEMBLY, HI SHORT	1:20



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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	NDA	DSI 9472	SHEET 1 OF 2
APPROVED	NDA	TITLE	SCALE
DE APPR.	NDA	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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98912

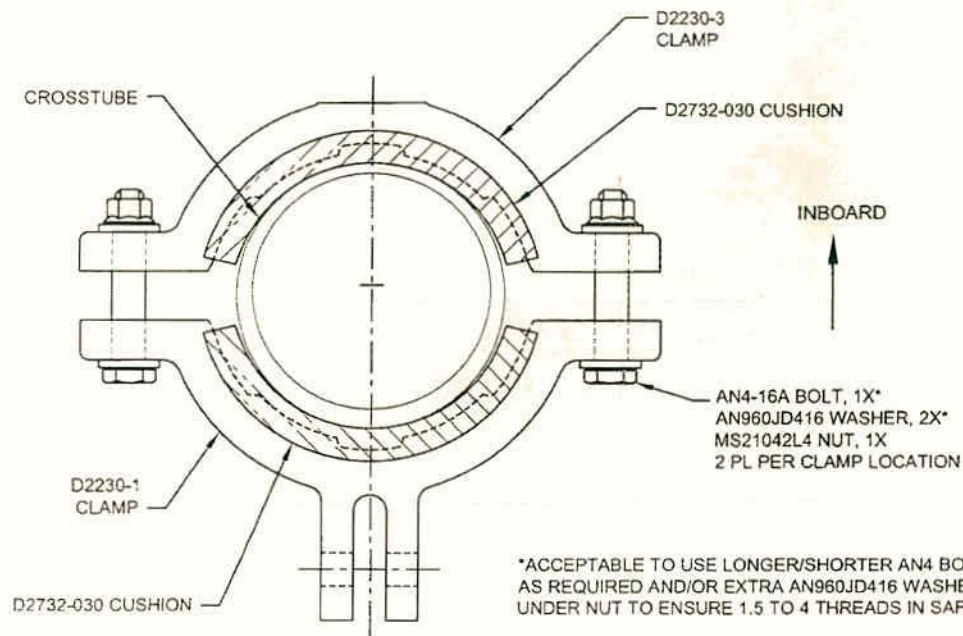


FIGURE 1: CLAMP DETAIL
OPTIONAL CLAMP CONFIGURATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
[Signature]

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>Q</i>	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>Q</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

21626

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

SM

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	NCA	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Work Order ID 98942-2

March-28-13 10:47:09 AM

98942

Page 1

Item ID: D350-591-213

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 4/10/13 Start Qty: 4.00

Required Date: 4/10/13 Req'd Qty: 4.00

Reference:

split

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MJS

Date: 13-04-01 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

fb

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

MJS 13-04-16

4 0 13-04-08